

February-13-14 7:38:19 AM

Page 1

4- Deburr

MLS 14-02-13

FF
14-02-13

Work Order ID 113405

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113405

Page 2

Item ID: D350-616-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full Emergency Litter

Start Date: 2/13/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/27/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

QC5- Inspect part completeness to step on W/O

0.00

105

0.00

QC

Memo

Quality Control

119

Pick Kit

0.00

119

0.00

Packaging

Memo

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

0.00

QC

Memo

Quality Control

DAS
27
3-89

12/21/13

DAS
6
9-89

14-2-13 1

Work Order ID 113405

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Page 3

Item ID: D350-616-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full Emergency Litter

Start Date: 2/13/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/27/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-616-011								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ship

MF 14-2-13

PL 14-02-13

MF

14-2-13

Picklist Print

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Page 1

Work Order ID: 113405

113405

Parent Item: D350-616-011

D350-616-011

Parent Item Name: Full Emergency Litter

Start Date: 2/13/14

Required Date: 2/27/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP E03.04.04ReformatKJ/RF
IPP Rev:F 08-12-10 rev.E as per dwg DD verified by:ec IPP REV:G
13.05.21 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2370-1		Manufactured	No				Each	4.0000		1			
D2370-1									**			FF	14-02-13
Litter Frame Assembly													

Location	Loc Qty	Loc Code
GA	1	
110565	1	
ST146A	1	
107743	1	
st196a	2	
110564	1	
110567	1	

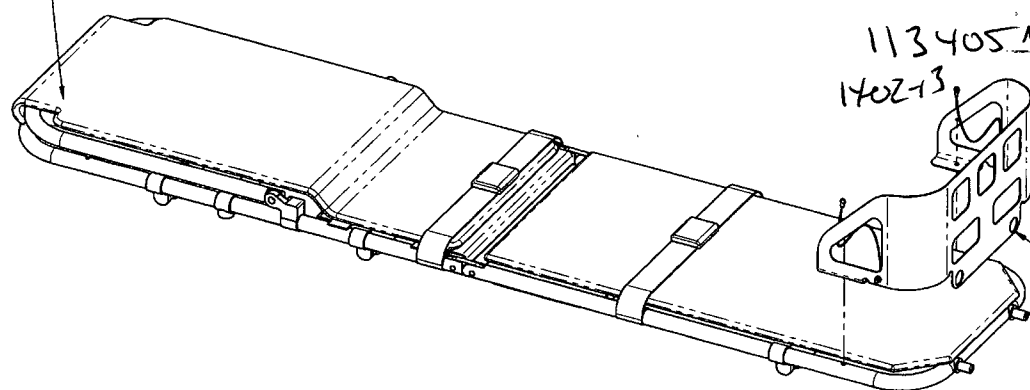
DAS
6
9-89

D350-616-013		Manufactured	No				Each	0.0000		1			
D350-616-013									**			710 691	8
Deck Plate & Tie Down													

D4812-041		Manufactured	No				Each	1.0000		1			
D4812-041									**			FF	14-02-13
Patient Stop Assembly													

Location	Loc Qty	Loc Code
ST229 111029	1	
102173	1	

D2370-1 LITTER FRAME ASSEMBLY



D2370-041 LITTER ASSEMBLY

NOTES:

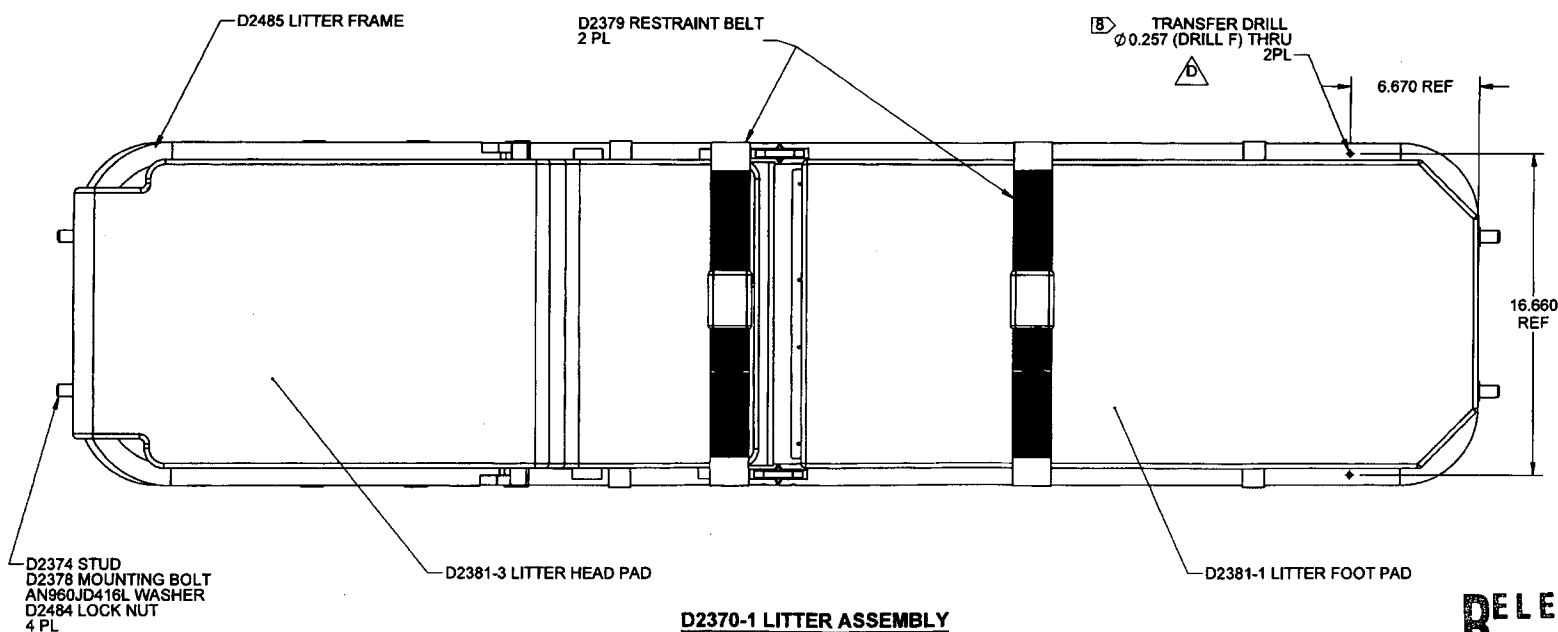
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 25.73 Lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D2370-041	LITTER ASSEMBLY
1	1	D2370-1	LITTER FRAME ASSY
2	1	D4812-041	PATIENT STOP ASSY

RELEASED
2013-05-16

D	Ø0.257 HOLES WERE Ø0.191 HOLES, 2PL (ZN C3-2), CREATED -1 AND -041 ASSEMBLIES, NEW DWG FORMAT	DB	13.03.27
C	ADD ALTERNATE FOR D2484, MS SCREWS, TAPPED HOLES AND 5.00 WAS 5.34	KE	06.11.21
B	ADDED Ø0.191 HOLES	KE	98.06.09
A	NEW ISSUE	NA	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/	D2370	SHEET 1 OF 2
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	LITTER ASSEMBLY	NTS
DATE	13.03.27	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN960JD416L	WASHER



D2370-1 LITTER ASSEMBLY

RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QS1 044 METHOD 6.6
- 7) WEIGHT: 24.69 Lbs
- 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/1	D2370	SHEET 2 OF 2
APPROVED	1/1	TITLE	SCALE
DE APPR.	1/1	LITTER ASSEMBLY	NTS
DATE	13.03.27	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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Work Order ID 113405

February-13-14 7:38:19 AM

113405

Page 1

Label only

Item ID: D350-616-011

Revision ID:

Item Name: Full Emergency Litter

Start Date: 2/13/14

Start Qty: 1.00

1

Required Date: 2/27/14

Req'd Qty: 1.00

1

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJDate: 14-02-13

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D350-616

G

100

0.00

MLJ 14-02-03***100***

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-616-011
CHG006

101

0.00

101

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D2370

2- Transfer drill using D4812-041 as template and open to size 0.257" as per
Dwg D2370 AND DT9935 DRILL JIG

3- Ensure fit of D4812-041 and remove for shipping

D4812-041 MUST STAY WITH LITTER FRAME

4- Deburr

FF 14-02-13

